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D3490-1

Job Sheet 194508



Part No: D3490-1

Job Qty: 20 pcs

Part Name: Cross Bolt Spacer



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/3/19

Job Tracking No:

Due Date: 5/20/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP Rev:A New Issue 06-03-03 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Hardinge - 1	20 pcs	5/20/19	5/20/19	0.00	0.33	Hardinge - 1		JBD 19/05/19
120	QC 8	20 pcs	5/20/19	5/20/19	0.00	0.00	QC 8 - 12		mL 19/06/05
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
145	QC 6	20 pcs	5/20/19	5/20/19	0.00	0.00	QC 6 - 9		N/A 19.06.06
							QC 6 - 68		
							QC 6 - 61		
							QC 6 - 40		
150	Packaging 3-1 - Stock - B4B	20 pcs	5/20/19	5/20/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		

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				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	BE
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160	QC 21 - SA	20 pcs	5/20/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

Part Op **100** - Hardinge - 1-TURN AS PER FOLIO FA628 & DWG D3490
 Descriptions: **120** - QC8- Inspect parts - second check
150 - Identify as per dwg & Stock Location: *LG001*
160 - QC21- Final Inspection - Work Order Release)

JUN 10 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6T0.500W.049	6061-T6 Round Tube .500 X.049W	5.3200 ft (.266 ea)	100-Hardinge - 1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Hardinge - 1	M6061T6T0.500W.049	5	74	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Crossbolt Spacer	0.500inches + 0.006 - 0.001	0.506 0.499		
2	Crossbolt Spacer	0.049inches ± 0.010	0.059 0.039		
3	Crossbolt Spacer	0.402inches + 0.006 - 0.001	0.408 0.401		
4	Crossbolt Spacer	3.085inches + 0.030 - 0.000	3.115 3.085		
5	Crossbolt Spacer	0.050inches ± 0.010	0.060 0.040		
6	Crossbolt Spacer	45Degrees ± 0	45 45		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S186298



Part: D3490-1

Job No: 194508

Serial No/Batch: S186298

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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